

Date: Wednesday, 11/23/2005 3:48:29 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 CARGO MIRROR
Job Number : 24945	
Estimate Number : 10095	
P.O. Number : N/A	Part Number : D044715011
This Issue : 11/23/2005 S.O. No. : N/A	Drawing Number : D3243REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 23461	Material : Manufacture in multiples of 10
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 12/22/2005 Qty: 10 Um: Each
Checked & Approved By : <u>SEE COMMENT BELOW</u>	
Comment : Est Rev:A 04.02.18 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011 CHG001

2.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------

**Comment:** Qty.: 0.5359 sf(s)/Unit Total : 5.3592 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: m. 0556

EP 05/12/11 10

3.0	SHEAR	SHEAR
-----	-------	-------

**Comment:** SHEAR

Cut blank: 6.600" x 12.00" grain along 12.000"

EP 05/12/11 10

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA385 and Dwg D3243 Stack of 10

Identify as D3243-1

EP 05/12/11 10

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

EP 05/12/11 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/23/2005 3:48:29 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 24945

Part Number: D044715011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC8

SECOND CHECK

J.L

05.12.11

10



Comment: SECOND CHECK

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 05/12/13

10

8.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

SB 05/12/15

10

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FF 05/12/15

10

2-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 01 21

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D32431

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3243-1

Bracket

B24945

SB 05/12/15

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/23/2005 3:48:29 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 24945

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

~~13.0~~

FE032EF

Inserts

11



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 FE-032EF

Insert

M 18484

SB 05/12/15

10

~~12.0~~

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

12.0



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3244-

SB 05/12/15

10

15.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D1048

Clamp

B28480

16.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D1049

Saddle

B23481

17.0

D2010104

Mirror Arm 219/500



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2010-104

Arm

B24969

18.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2011-101

Mirror

B24967 ymc

6 mg B24557
B24557

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/23/2005 3:48:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 24945

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D3243041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3243-041

Bracket

B24945

~~1-000000~~

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 ALS4-1032-130Insert

M18293

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A

Bolt

M18310

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10 Screw

M14741

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L

Washer

M18235

10/1/27 (10)

24.0

Q04

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C20610112710

23.1 Assemble as per Brg.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/23/2005 3:48:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 24945

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location: _____

RAW A *6/1/30 70*

26.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/31

(10)

DD 06/01/31

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

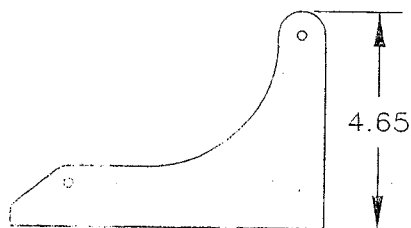
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

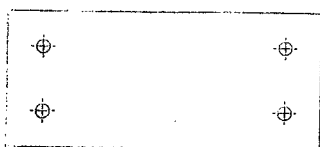
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.138 (TYP)



INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 $\begin{smallmatrix} +0.030 \\ 0.000 \end{smallmatrix}$

D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
02.03.10

8.581
8.206
7.706

11.920
11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

GRAIN
DIRECTION

1.375

5.273

4.214
R0.25 (TYP)
3.339
R0.38 (TYP)
5.494

3.714

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

0.500
0.000

0.750
0.500
0.000

6.560
5.810
5.360

D3243-041 BRACKET ASSEMBLY
D3243-1 BRACKET

1. MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
2. FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
3. BREAK ALL SHARP EDGES 0.005 TO
0.010
4. ALL DIMENSIONS ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 24945
Description: BRACKET		Part Number: D3243
Inspection Dwg: D3243	Rev: 4	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	± 0.018	0.498	-		vern	
0.750	± 0.010	0.741	-		"	
5.360	± 0.010	5.361	-		"	
5.810	± 0.016	5.806	-		"	
6.560	± 0.010	6.556	-		vern	
$\phi 0.290$	± 0.005 -0.001	0.292	-		"	
$\phi 0.201$	± 0.005 -0.001	0.204	-		"	
0.500	± 0.010	0.501	-		"	
5.273	± 0.018	5.276	-		vern	
1.375	± 0.016	1.379	-		"	
11.420	± 0.010	11.421	-		"	
11.920	± 0.010	11.918	-		"	
8.581	± 0.010	8.584	-		vern	
R.050	± 0.030	0.500	-		R.G	
R.025	± 0.030	0.250	-		R.G	

Measured by: ED	Audited by: J.L	Prototype Approval:
Date: 05/12/11	Date: 05-12-11	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	